

Work Order ID 129497

Thursday, February 12, 2015 9:24:55 AM

129497

Page 1

Item ID: D3805-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 2/13/15

Start Qty: 16.00

16

Cust Item ID:

Required Date: 2/26/15

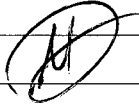
Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: Date: 5-2-12

Tooling:

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3805

C

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3805

Dwg Rev: CProg Rev: C

2-Deburr if necessary

0.00

1602/15/02/12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

1602/15/02/12

Work Order ID 129497

129497

Page 2

Thursday, February 12, 2015 9:24:55 AM

Item ID: D3805-1 Accept ***N19000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plate
 Start Date: 2/13/15 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 2/26/15 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130					DAS 30 9-89				
Brake NC	Memo	0.00							
Brake NC	Form as per Dwg D3805 using Jigs DT8261 and DT8326								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

FEB 13 2015

15/02/23

16 5hr
15/3/23

Work Order ID 129497

Thursday, February 12, 2015 9:24:55 AM

129497

Page 3

Item ID: D3805-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Plate

Stop ***NS2***

Start Date: 2/13/15

Start Qty: 16.00

16

Cust Item ID:

Required Date: 2/26/15

Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: U/A-001

0.00

150

Packaging

Memo

0.00

Packaging

x16 15-02-23 MAL

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

15/2/23 [Signature]

[Signature] 15-2-23

" Picklist Print

Thursday, February 12, 2015 9:24:59 AM

Page 1

Work Order ID: 129497

129497

Parent Item: D3805-1

D3805-1

Parent Item Name: Plate

Start Date: 2/13/15

Required Date: 2/26/15

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 08-07-15 new issue DD verified by:EC
IPP Rev:B 08-07-30 redesign flat pattern DD verified by:EC
IPP Rev:C 08-09-23 redesign flat pattern DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	630.6887	1.862	32			

M304S18GA

304/316 .050 Sheet

02/15/02/12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	630.6887	
124572	23	
125552	19.75	
M126647	24.6112	
M128254	17.4387	
M128435	27	
M128864	31.5964	
M129530	53.5	
M130345	28	
M130923	88.7924	
M131384	317	

16.8333 > 33.466
16.8333

DART AEROSPACE LTD		Work Order:	129497
Description: Wearplate		Part Number:	D3805-1
Inspection Dwg: D3805	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

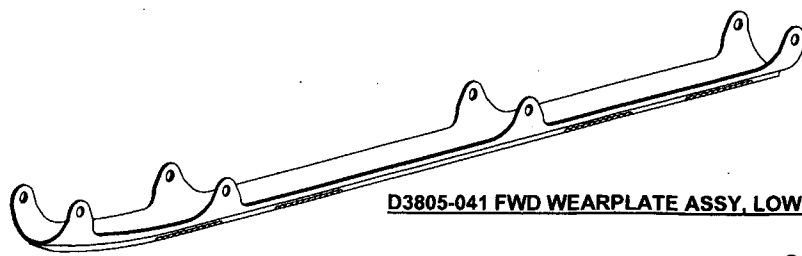
[illegible]

Measured by:	De	Audited by:	38	Preliminary Approval:	
Date:	15/02/12	Date:	088 FEB 12 2015	Date:	

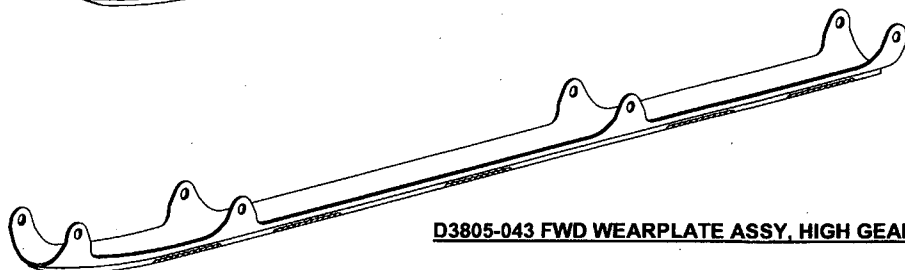
Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ	
B	12.02.01	Dwg Rev updated	KJ	

8 7 6 5 4

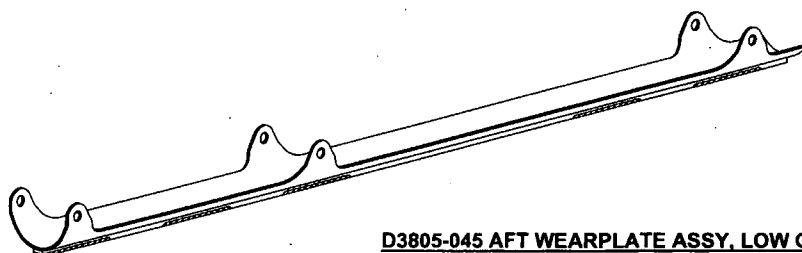
3 2 1



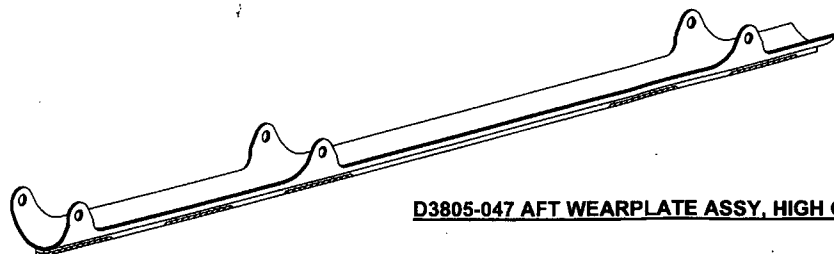
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

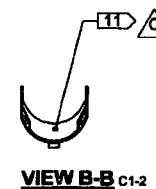
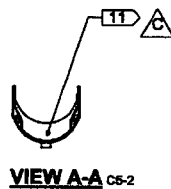
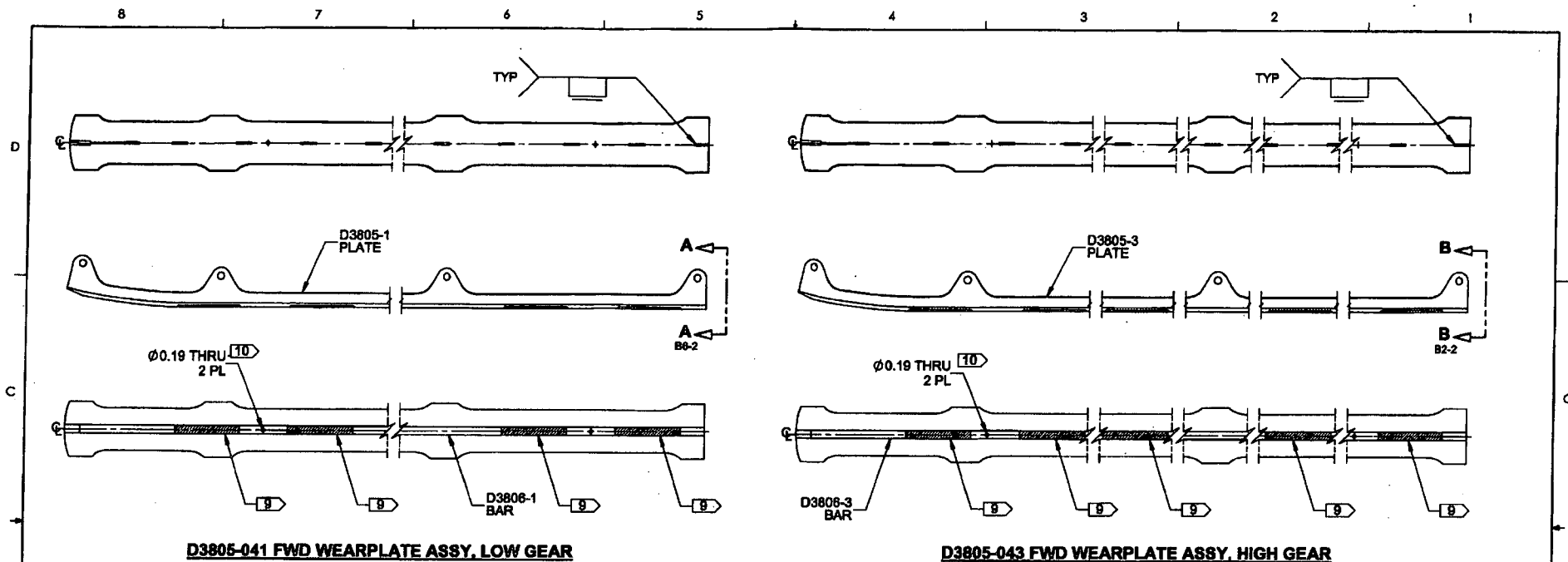
△

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT

RELEASED
2014-04-13

15-2-12
129407

C	REMOVE ITEMS 19, 20, 21, 22 AND 32 FROM BOM (ZN C4-1). REVISE NOTE 11, SHEETS 283 (ZN A8-2, B2-2, B6-2, A8-3, B2-3, B6-3)	DB	13.10.04
B	REVISED D3805-1F/3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PAR11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	ASS	D3805	SHEET 1 OF 8
APPROVED	ASS	TITLE	SCALE
DE APPR.	ASS	WEARPLATE ASSY	NTS
DATE	13.10.04	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



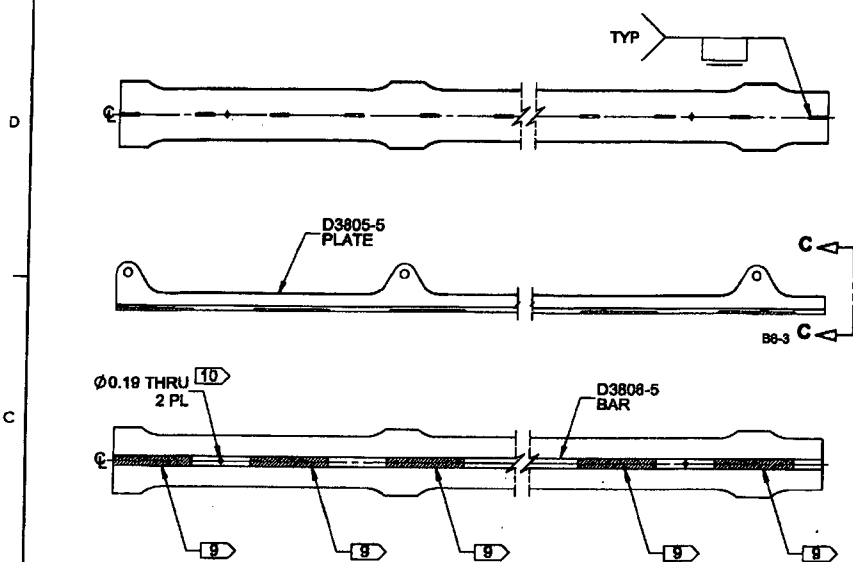
RELEASED
2014-04-17

NOTES:

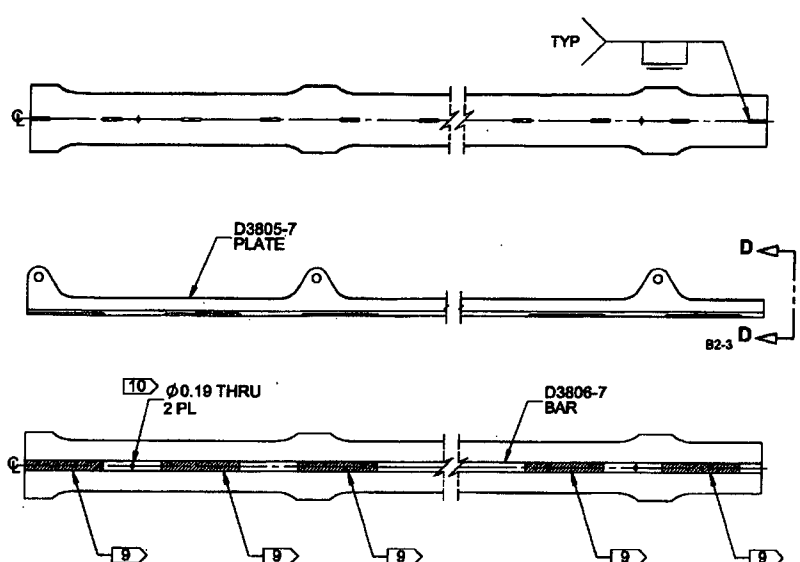
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

DESIGN	QD	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	ALS	DRAWING NO. D3805	REV. C
MFG. APPR.	DB	SHEET 2 OF 8	
APPROVED	HP	TITLE	SCALE
DE APPR.	HP	WEARPLATE ASSY	NTS
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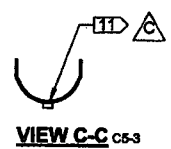
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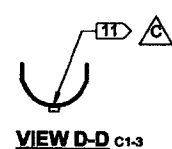
D3805-045 AFT WEARPLATE ASSY.



D3805-047 AFT WEARPLATE ASSY.



VIEW C-C C5-3



VIEW D-D C1-3

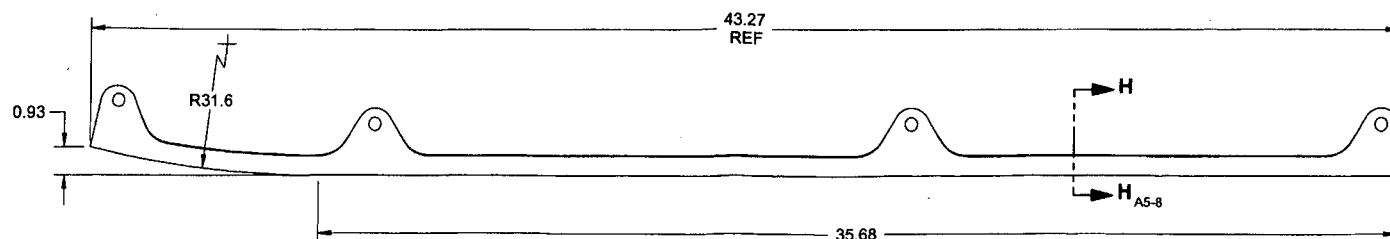
RELEASED
2014-04-17

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.18 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

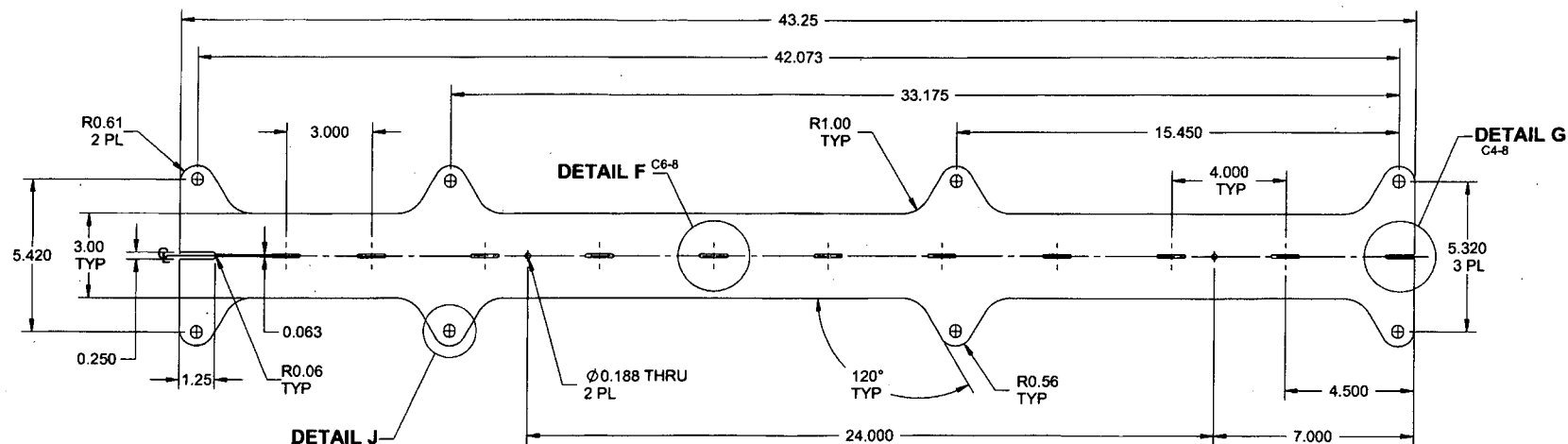
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DRAWN	DB	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3805	SHEET 3 OF 8
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D3805-1 PLATE
(MAKE FROM D3805-1F)



D3805-1F PLATE

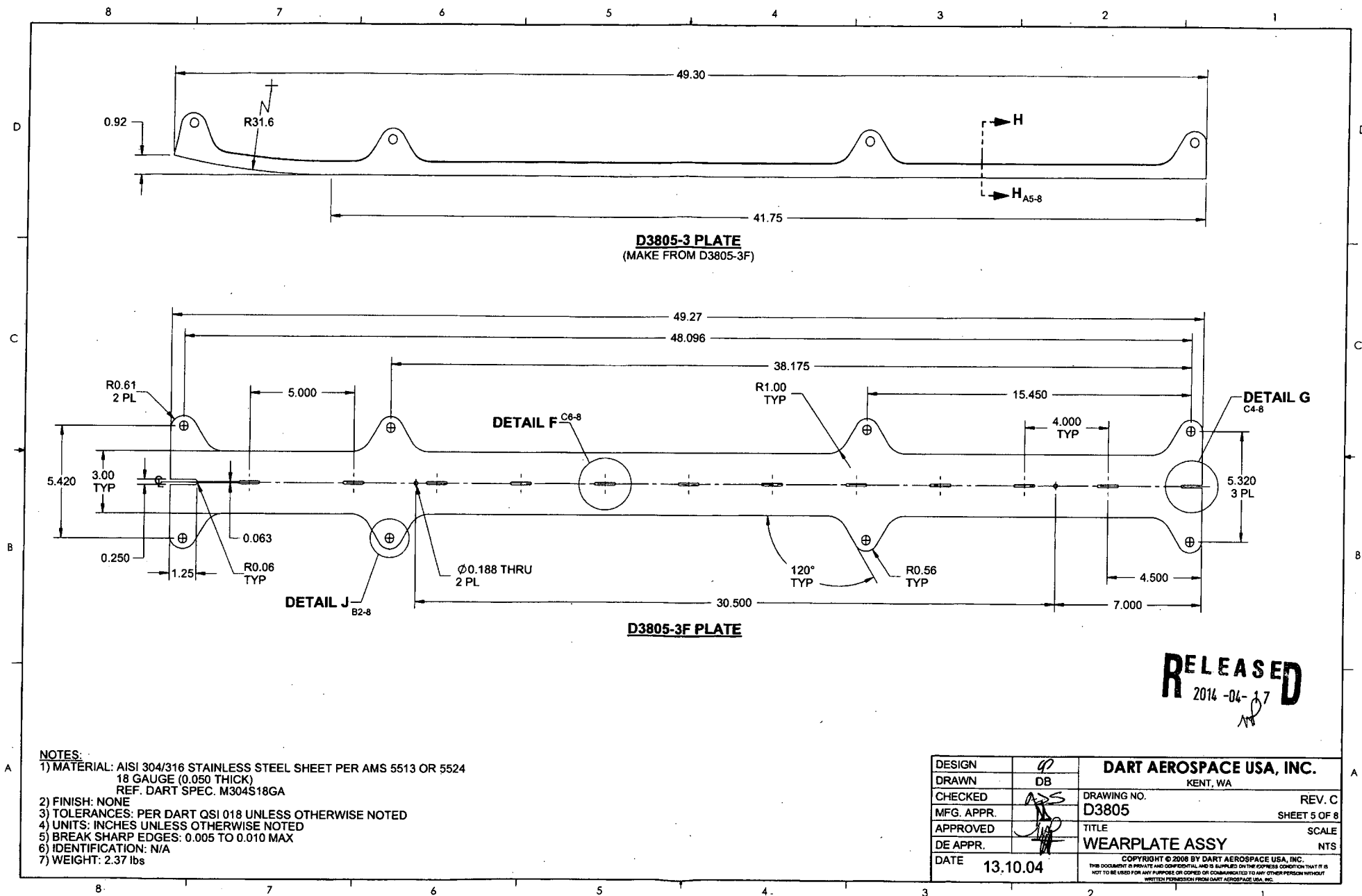
RELEASED
2014-04-17

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.11 lbs

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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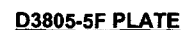
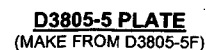
8 7 6 5 4 3 2 1



RELEASED
2014-04-17

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.37 lbs

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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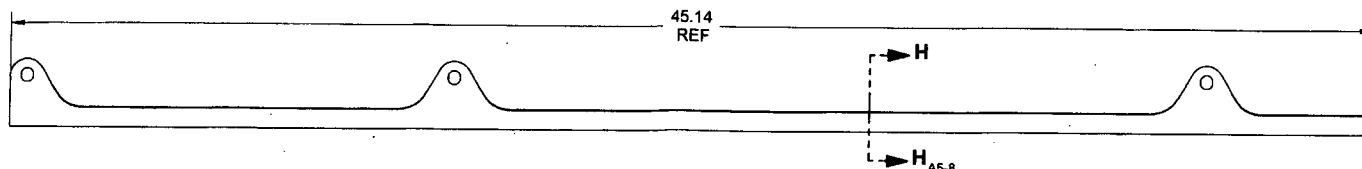


RELEASE
2014-04-17

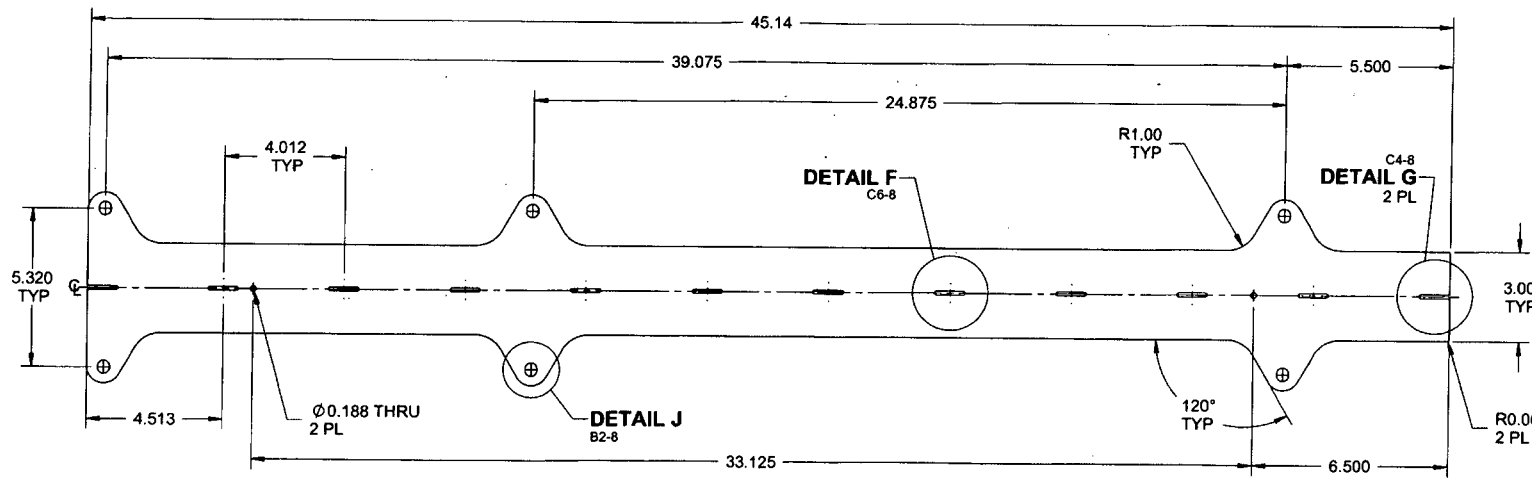
- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.06 lbs

DESIGN	gp	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 6 OF 8
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1



D3805-7 PLATE
(MAKE FROM D3805-7F)



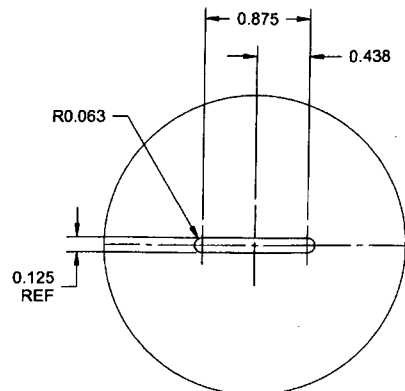
D3805-7F PLATE

RELEASED
2014-04-17

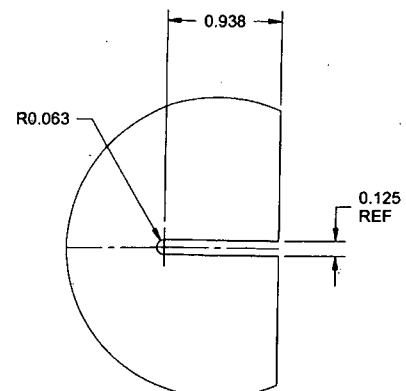
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.13 lbs

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 7 OF 8
APPROVED		TITLE	SCALE
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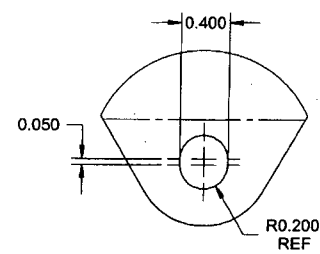
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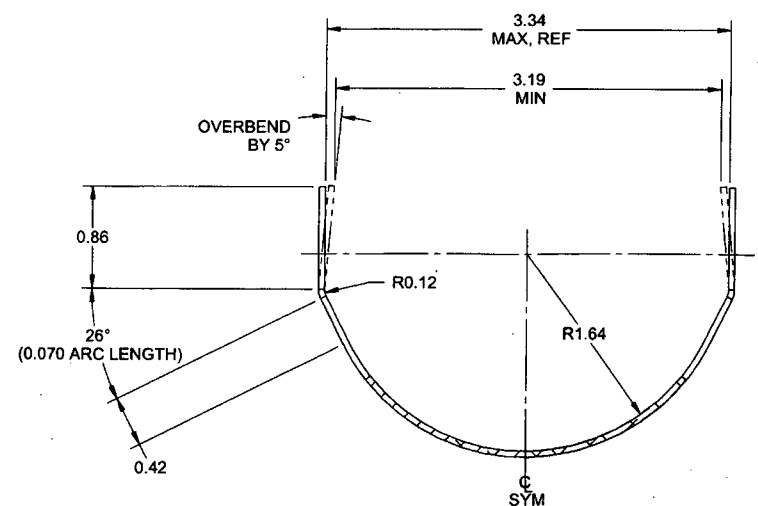
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
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C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

RELEASED
2014-04-10

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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